



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-37
Job Sheet 191283



11778
April 20

Part No: 20NR-37

Job Qty: 6 pcs

Part Name: Keeper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~

Description:

Note: DWG 20NR-37 Rev.4 IPP Rev. A 19.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	6 pcs	5/10/19	5/10/19	0.00	0.75	Waterjet - Omax	de 19/04/18
110	QC 2	6 pcs	5/10/19	5/10/19	0.00	0.00	QC 2 - 1	SCRAP
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

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120 NV5000 - 1 - B4B	6 pcs	5/10/19	0.00 1.50	QC 2 - 64	
				NV5000 - 1 - B4B	
130 QC 2	6 pcs	5/10/19	0.00 0.00	NV5000 - 2 - B4B	
				QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
140 QC 8	6 pcs	5/10/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Outsource - 1 - Heat Treat	6 pcs	5/10/19		QC 8 - 47	
160 Outsource - 15 - Nickel Plate	6 pcs	5/10/19		QC 8 - 40	
170 Packaging 2-2 - Receive - B4B	6 pcs	5/10/19	0.00 0.00	MEI001-VC	
				GRO002-VC	
				Packaging 2 - 1 - B4B	

				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
180	QC 6	6 pcs	5/10/19	0.00 0.00	QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
190	Packaging 3-2 - Stock - B4B	6 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200	QC 21 - SA	6 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ 2-Debur if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - 1-Machine as per folio FC 737 FOLIO REV: AA DWG REV: 4 2-Debur
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
150 - 1-Issue P/O; _____ RC 45-48 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required
 NOTE DROP SHIP TO FINISHER HEAT TREAT to ship directly to SURFACE FINISH***
160 - -Issue P/O; _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after
 plating -Material type; 4140 -Certificate of Conformity is required
170 - (Receive & Inspect for Damage & Mat'l Certs) Receive
180 - (QC6- All purchased or subcontracted products)
190 - (Identify as per dwg & Stock Location: _____) Identify and Stock
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-1.000X10.000	AISI 4140 Steel Sheet/Plate	.5520 ft (.092 ea)	100-Waterjet - Omax - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-4140-S-1.000X10.000	1	42	0

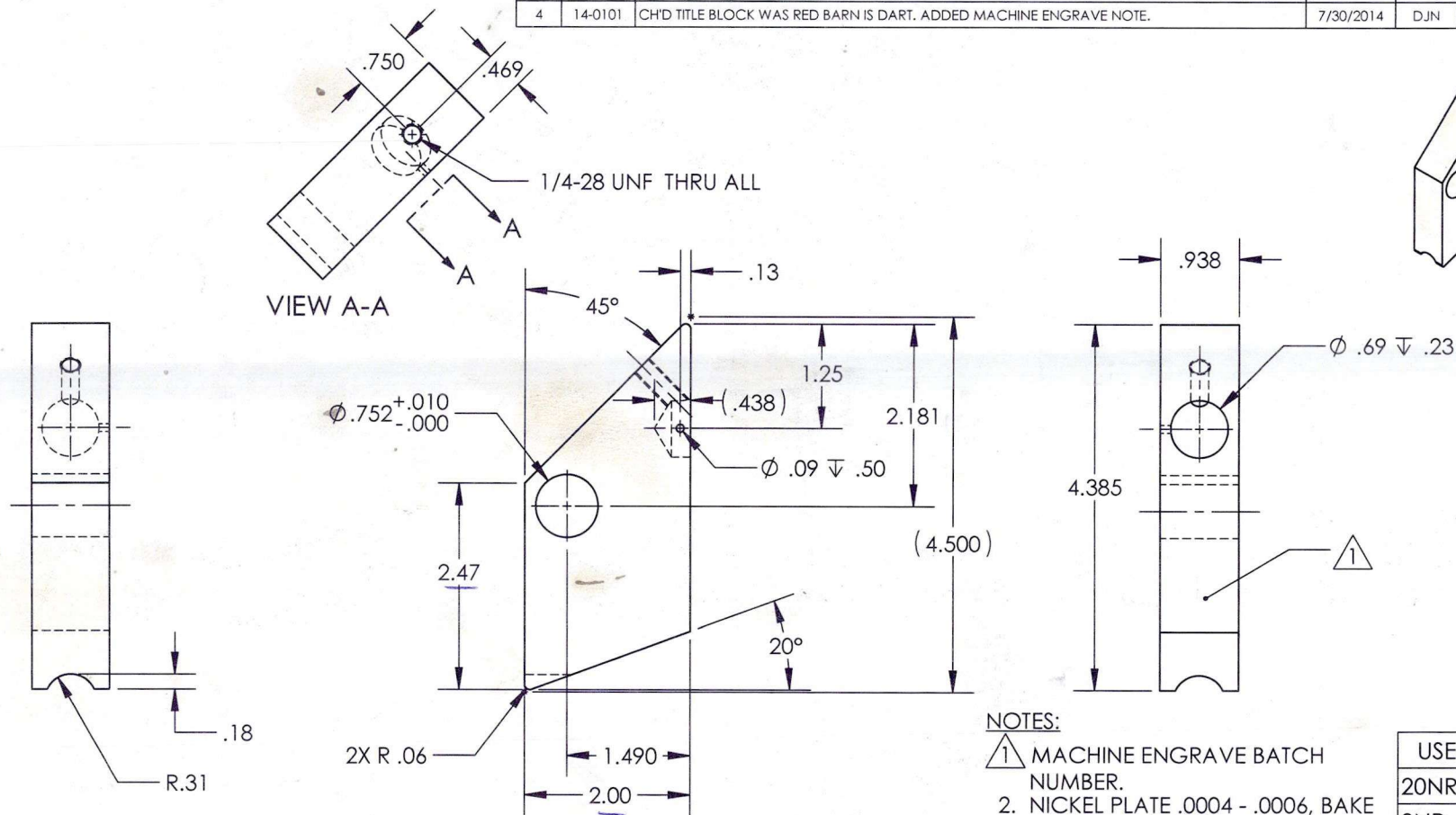
Part Specifications

Specifications could not be found.

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
2		AS DRAWN BY CANAM	7/18/2013
3		ADDED R.31 PER PARTS IN STOCK.	8/28/2013
4	14-0101	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE.	7/30/2014



NOTES:

- 1 MACHINE ENGRAVE BATCH NUMBER.
2. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

USED ON
20NR
8NR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191288 HUS
19-0226

DART AEROSPACE	
TITLE KEEPER	
DWG NO. 20NR-37	REV 4
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D Weil</i>
.XX ± .005 FRACTIONS ± 1/32	HEAT TREAT RC 45-48
.XX ± .01 ANGLES ± 5°	FINISH SEE NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1995
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-37	1	KEEPER	4140	1 X 2-1/8 X 4-5/8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S173624



Part: 20NR-37

Job No: 191283

Serial No/Batch: S173624

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 04/18/19